

# Work Order ID 71953

Thursday, July 14, 2011 10:15:20 AM



Page 1

Item ID:	D412-630-033	Accept		Setup	Start	
Revision ID:						
Item Name:	Heli Access Step LH Folding				Stop	
Start Date:	7/14/2011	Start Qty:	4.00			
Required Date:	7/22/2011	Req'd Qty:	4.00			
Reference:						

Approvals:	Process Plan:		Date:	11-07-14	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
IIN D412-630	Rev M								

100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & create labels per PPP D412-630-033 CHG003								

*8/16/14*

110		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg D412-630 p.14								
	Coat all hardware with LPS3 rust inhibitor								
	A/R LPS3 batch: <u>M116551</u>								
	COAT exposed HARDWARE WITH LPS PROCYON								
	A/R LPS PROCYON BATCH: <u>M114596</u>								

*EP 11/09/14 (4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 71953**

Thursday, July 14, 2011 10:15:20 AM

Page 2

Item ID: D412-630-033

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli Access Step LH Folding

Start Date: 7/14/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 4.00

Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		S u l o r / 14		<u>x4</u> LH			
130  Packaging Packaging	Pick Kit  Memo	0.00 0.00							
140  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00		S u l o r / 14		<u>x4</u> LH			

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D412-630-033

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step LH Folding

Start Date: 7/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-033								
	Location: _____								
	PPP Rev: <u>A</u>								
160		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

11/9/14

11-09-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 1

Work Order ID: 71953

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 7/14/2011


Required Date: 7/22/2011

Start Qty: 4.00

Required Qty: 4.00


Comments: IPP Rev:A New Issue 06-11-08 JLM  
IPP rev B ecn 1019, added d2807-041 EC verified by:DD  
IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2012-107  Clevis		Manufactured	No			110	Each	37.0000	1	4			
---	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--


Location	Loc Qty	Loc Code
----------	---------	----------

ST004	23	
71602	23	
WA005	14	
66811	14	

D2803-041  Bracket Assembly		Manufactured	No			110	Each	4.0000	1	4			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST149	4	
61724	2	
71006	2	

D2804-041  Bracket Assembly		Manufactured	No			110	Each	1.0000	1	4			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST150	1	
61726	1	

*Handwritten signature*  
7/14/08/30

*Handwritten signature*  
7/14/08/30

B46639 (1x)  
B71560 (3x)  
*Handwritten signature*  
7/14/08/30  
B70998 (2x)  
B71561 (2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

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Parent Item Name: Heli Access Step LH Folding

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 4.00

Required Qty: 4.00

D2807-041  
Door prop

Manufactured No

110 Each

19.0000

2

8

Location

Loc Qty

Loc Code

ST022

11

60540

2

69671

9

ST023

8

68494

8

D2813  
Washer

Manufactured No

110 Each

41.0000

2

8

Location

Loc Qty

Loc Code

ST023

41

69386

21

71169

20

D3562-041  
Step Assembly, LH

Manufactured No

110 Each

0.0000

1

4

D3395-1  
Bushing

Manufactured No

110 Each

123.0000

4

16

Location

Loc Qty

Loc Code

ST052

123

69387

20

70775

40

71563

63

*PS 11/08/30*

*B 71562 (1x)*

*7*

*PS 11/08/30*

*8*

*B 71951 (4x)*

*PS 11/08/30*

*PS 11/08/30*

*16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 71953

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 4.00

Required Qty: 4.00



Purchased No

110 Each

77.0000

2

8



*EB 11/08/30*

Location

Loc Qty

Loc Code

ST352

77

109148

7

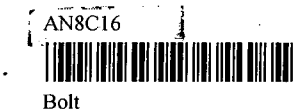
117366

20

117514

50

*8*



Purchased No

110 Each

37.0000

2

8



*EB 11/08/30*

Location

Loc Qty

Loc Code

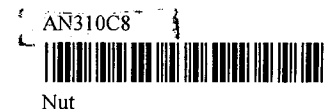
ST345

37

106066

37

*8*



Purchased No

110 Each

33.0000

2

8



*EB 11/08/30*

Location

Loc Qty

Loc Code

ST324

33

117771

23

118091

10

*8*



Purchased No

110 Each

180.0000

6

24



*EB 11/08/30*

Location

Loc Qty

Loc Code

ST357

180

117460

180

*24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 71953

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1515H3

Purchased

No

110

Each

164.0000

4

16



Washer

Location

Loc Qty

Loc Code

ST277

164

116373

6

117460

58

118078

100



*EP 11/08/30*

1118384 (16x)

NAS1515H5L

Purchased

No

110

Each

68.0000

4

16



WASHER

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

28

111359

28



*EP 11/08/30*

1118378 (16x)

NAS1515H8

Purchased

No

110

Each

227.0000

4

16



Washer

Location

Loc Qty

Loc Code

ST278

227

111275

35

111411

192



*EP 11/08/30*

7  
9

Thursday, July 14, 2011 10:15:28 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, July 14, 2011 10:15:28 AM

Page 5

Work Order ID: 71953

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

110

Each

876.0000

4

16



Nut



Loc Code

Location

Loc Qty

FG

72

103691

72

ST301

804

112314

65

118077

739

MS24693-C280

Purchased

No

110

Each

41.0000

2

8



Screw



Loc Code

Location

Loc Qty

ST310

40

115594

10

118093

30

ST318

1

111279

1

D2806-1

Manufactured

No

130

Each

26.0000

2

8



Bushing



Loc Code

Location

Loc Qty

ST022

26

68492

6

70885

20

Thursday, July 14, 2011 10:15:28 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Thursday, July 14, 2011 10:15:28 AM

Page 6

Work Order ID: 71953

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 4.00

Required Qty: 4.00

D2806-3 Manufactured No

130 Each

27.0000

2 8



Bushing

Location

Loc Qty

Loc Code

ST022

27

69401

7

70886

20

D2810-5 Manufactured No

130 Each

8.0000

1 4



Strut

Location

Loc Qty

Loc Code

ST265

8

52034

1

69402

7

D3396-1 Manufactured No

130 Each

38.0000

2 8



Spacer

Location

Loc Qty

Loc Code

ST052

38

46748

8

69906

30

Thursday, July 14, 2011 10:15:28 AM

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, July 14, 2011 10:15:28 AM

Page 7

Work Order ID: 71953

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 4.00

Required Qty: 4.00

AN4C6A Purchased No

130 Each

298.0000

1

4



Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

294

116704

19

117619

50

117794

50

117872

75

118191

100

117872

AN4C10A Purchased No

130 Each

73.0000

1

4



Bolt

Location

Loc Qty

Loc Code

ST356

73

112243

43

114523

30

112243

AN5C15A Purchased No

130 Each

117.0000

2

8



Bolt

Location

Loc Qty

Loc Code

ST338

23

118191

23

ST339

94

111819

4

117764

13

117885

25

118232

2

118267

50

117885

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 4.00

Required Qty: 4.00

AN44C7A

Purchased

No

130

Each

65.0000

1

4 ~



Eyebolt

Location

Loc Qty

Loc Code

ST362

65

109013

25

111308

40

109013

AN4C15A

Purchased

No

130

Each

93.0000

2

8 ~



Bolt

Location

Loc Qty

Loc Code

ST358

93

115835

11

117441

32

117795

50

117441

NAS1515H4

Purchased

No

130

Each

178.0000

7

28 ~



Washer

Location

Loc Qty

Loc Code

ST277

178

111525

2

116169

3

117460

50

117735

75

118078

48

117460 21P  
117735 74

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1515H5

Purchased

No

130

Each

163.0000

7

28



Washer



118384

*[Signature]*

## Location

## Loc Qty

## Loc Code

FG	40	
103286	20	
103691	20	
ST277	123	
103286	100	
109430	23	

MS21043-4

Purchased

No

130

Each

696.0000

4

16



Nut



118378

*[Signature]*

## Location

## Loc Qty

## Loc Code

FG	40	
104603	40	
ST301	656	
117601	156	
117793	500	

MS21043-5

Purchased

No

130

Each

567.0000

3

12



Nut



*[Signature]*

## Location

## Loc Qty

## Loc Code

FG	20	
101418	20	
ST301	447	
112314	347	
116548	100	
ST314	100	
118159	100	

112314

**Dart Aerospace Ltd**

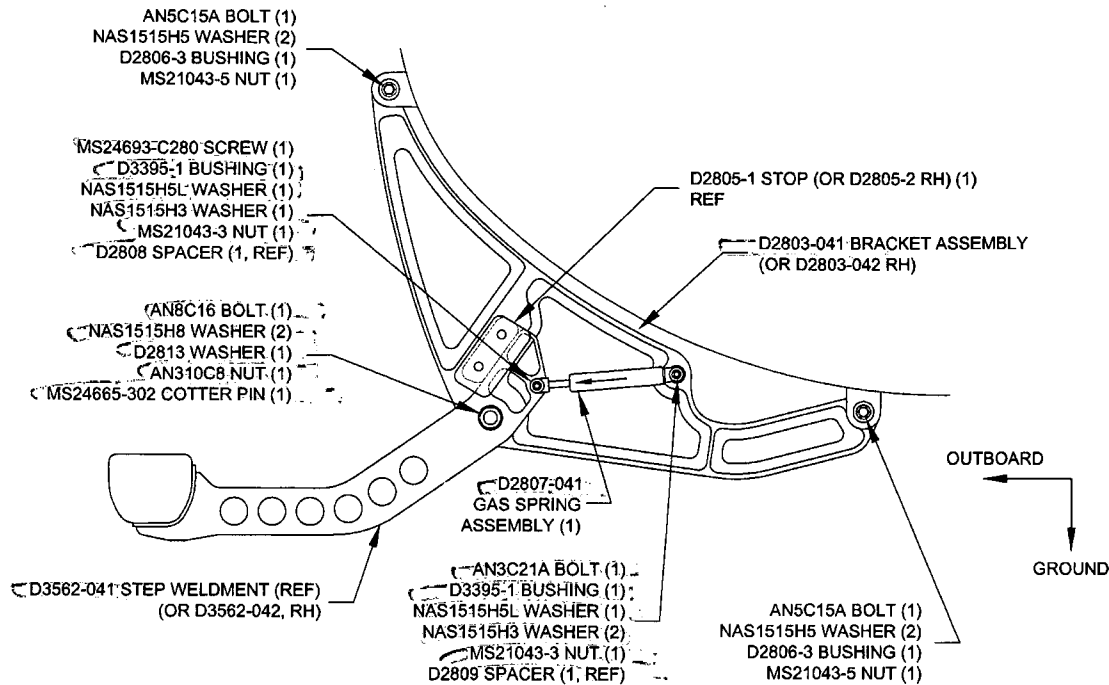
W/O:		WORK ORDER CHANGES					
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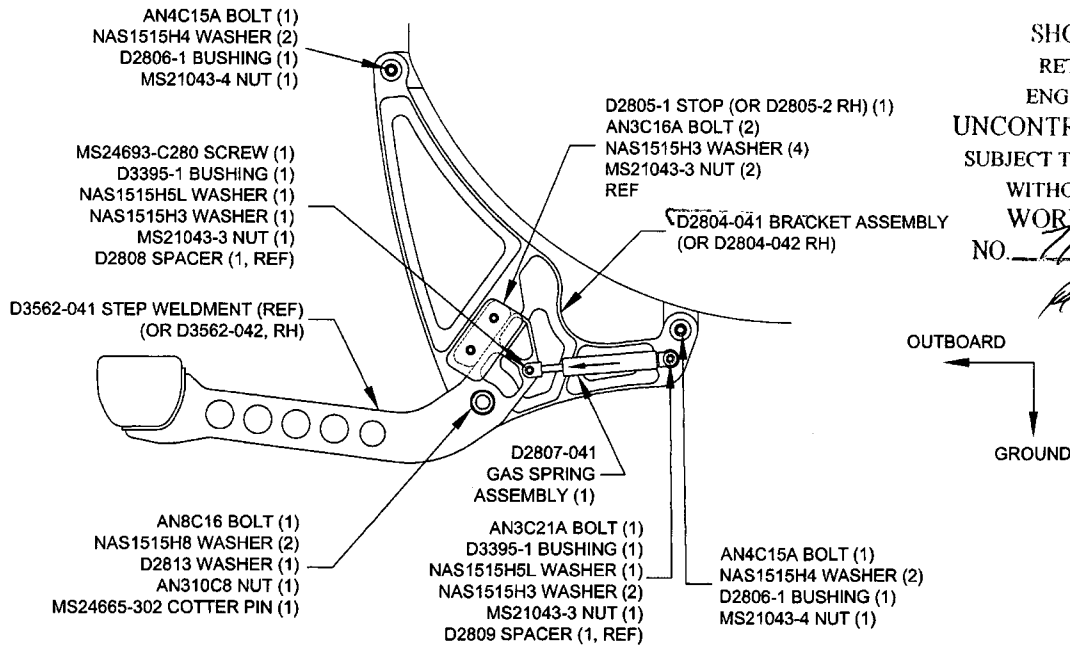
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**D412-630-033/-034 Heli-Access-Step™ Installation**

**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation  
(View rotated 90° CW)**



**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation  
(View rotated 90° CW)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71953

*AK-07-14*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

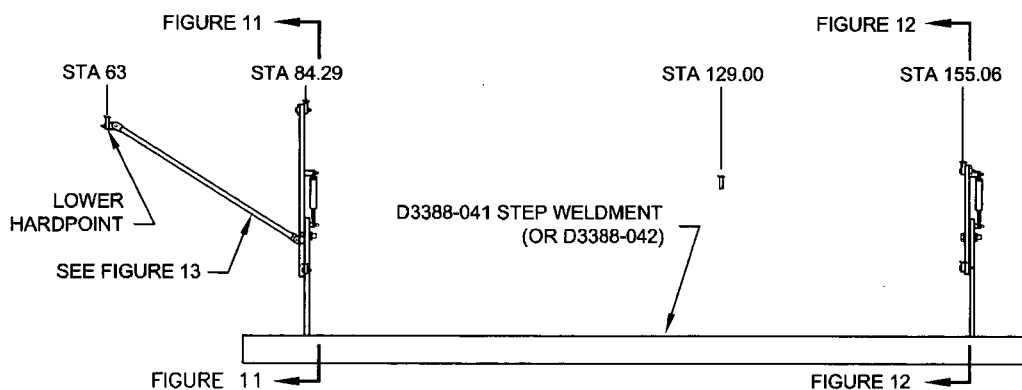
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

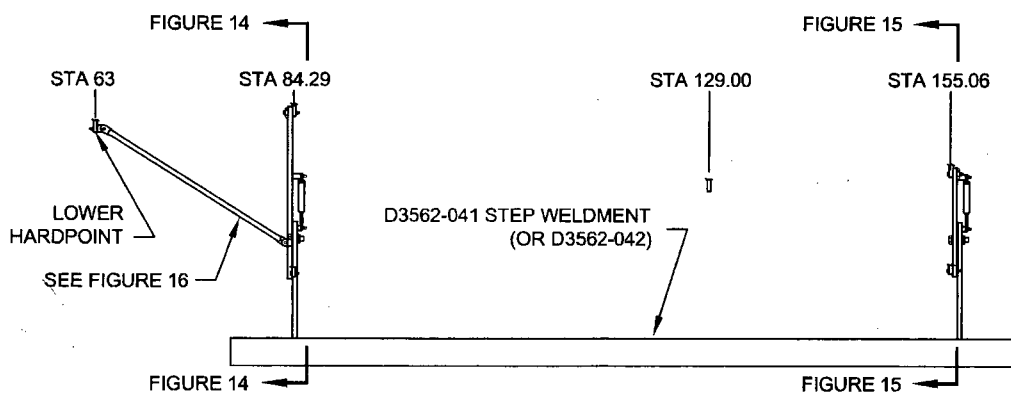
**NOTE:** Date & initial all entries

REFERENCE ONLY

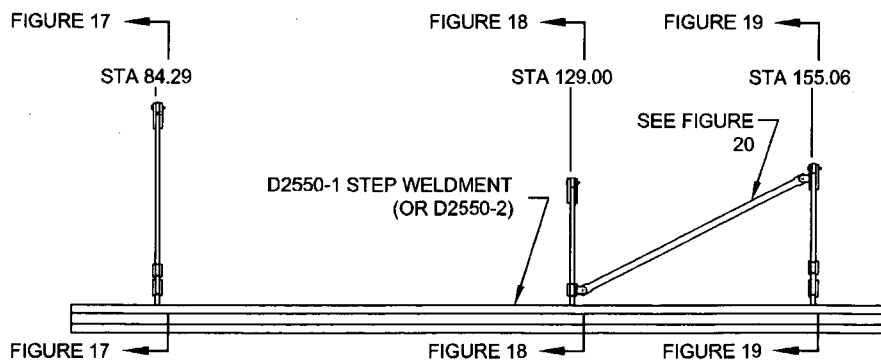
**D412-630-023 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)**  
**D412-630-024 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)**



**D412-630-033 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)**  
**D412-630-034 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)**



**D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)**  
**D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)**



**FIGURE 3 – D412-630 Heli-Access-Step™ Installations**

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Revision: **M**  
 Date: 08.12.12

REFERENCE ONLY

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)